

Date: Thursday, 3/13/2008 1:02:15 PM
User: Kim Johnston

Process Sheet

13

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 412 X-TUBE INST,LOW NARROW FWD
Job Number : 38013	
Estimate Number : 13209	
P.O. Number :	Part Number : D412664105TRN
This Issue : 3/13/2008 S.O. No. :	Drawing Number : D412-664-145 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LANDING GEAR	Drawing Revision : C
Previous Run : 38012	Material :
Written By :	Due Date : 3/28/2008 Qty: 1 Um: Each
Checked & Approved By : <u>JF 080313</u>	
Comment : Est Rev: A New Issue 08-03-06 DD verified by: ec	

Additional Product

Job Number: 

Seq. #:	Machine Or Operation:	Description :
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1.0	D6019128	Crosstube Material
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6019-128 Crosstube B.32310

Check OD = 2.7500"; ID =

J.F. / a.m 08.03.24 ①

2.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
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Comment: MORISEIKI

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA689

2-Turn first side as per Folio FA689

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-145.

J.F. / a.m

08.03.24 ①

3.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

J.F. / a.m 08.03.24

4.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
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Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA689

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-145

3- Remove sand and plugs

J.F. / a.m

0803.240

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/13/2008 1:02:15 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 412 X-TUBE INST, LOW NARROW FWD

Job Number: 38013

Part Number: D412664105TRN

Job Number:



Seq. #:

Machine Or Operation:

Description:

4-Scribe part # and batch # using vibrating stylus as per Dwg D412-664-145
engrave on outside of tube)

Inside of Cuff (Donot

5.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

J.F. / am 08.02.24 ①

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

ML 08/03/27 ①

7.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

AWM
8-3-31

1-Polish entire outside surface of crosstube

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

8-3-31

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DP 8-3-31

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Identify and stock in kanban rack

Location: 46

DP 8-3-31

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/03
JF

Job Completion



8-3-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>qp</i>	DRAWN BY <i>qp</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D412-664-145	REV. C SHEET 1 OF 3
DATE 07.03.29		TITLE CROSSTUBE ASS'Y (412 LOW-N FWD) NTS	
A	06.12.21	NEW ISSUE	
B	07.03.01	CHG RUBBER CUSHION	
C	07.03.29	CHG CLAMP & RUBBER CUSHION LGTH.	

RELEASED

07.04.24 *[Signature]*

PARTS LIST:

Qty	Part Number	Description
X	D412-664-145	CROSSTUBE ASSEMBLY (412 LOW-NARROW FWD)
1	D6019-128	CROSSTUBE
1	D2856-250-842	ABRASION STRIP
2	D2893-1	SUPPORT
1	D3189-3	CHAFING SHIELD
4	D3595-063-450	RUBBER CUSHION
2	MS21920-24	CLAMP
4	MS21920-25	CLAMP (OR MS21920-26)
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

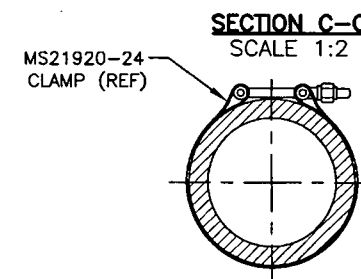
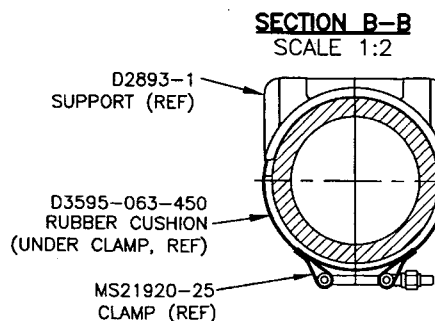
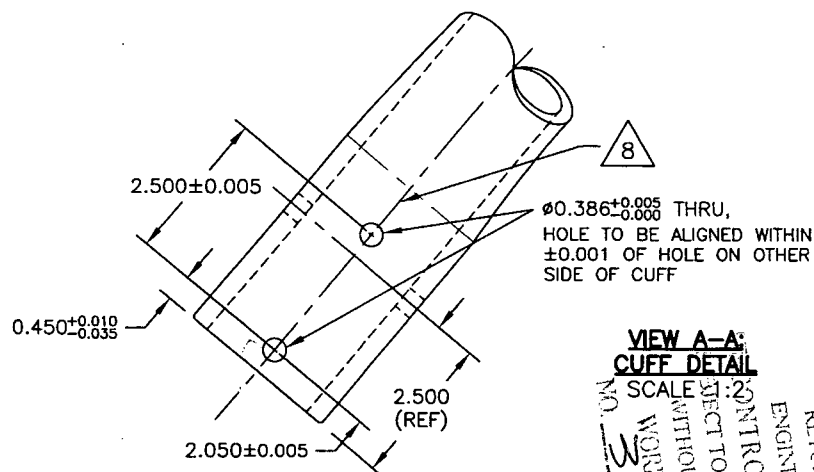
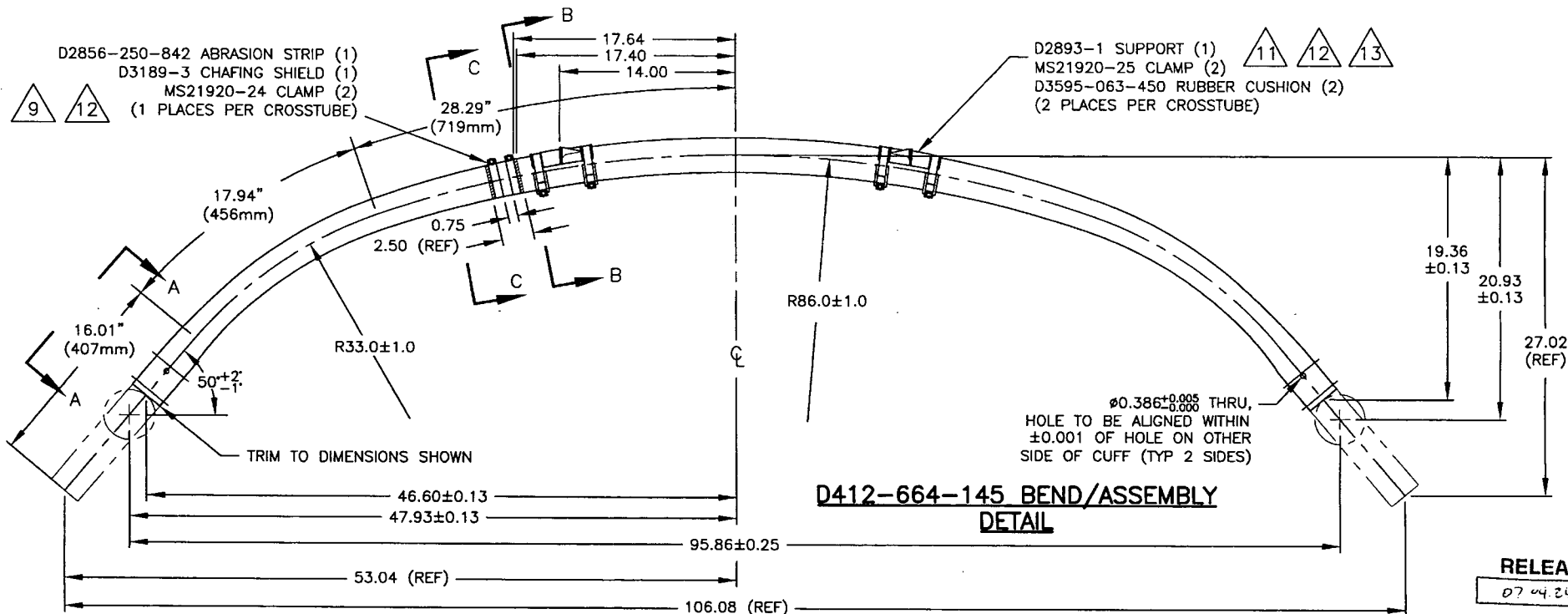
GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6019-128
FINISHED LENGTH = 124.48±0.020 (BEFORE BENDING/TRIMMING)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE, EXCEPT FOR D3189-3 CHAFING SHIELD AND ASSOCIATED HARDWARE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-XXX-YYY ABRASION STRIPS WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) APPLY A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2893-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 12) INSTALL MS21920-25 CLAMPS (OR -26) WITH D3595-063-450 RUBBER CUSHIONS TO SECURE D2893-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE CROSSTUBE SUPPORT.
- 13) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

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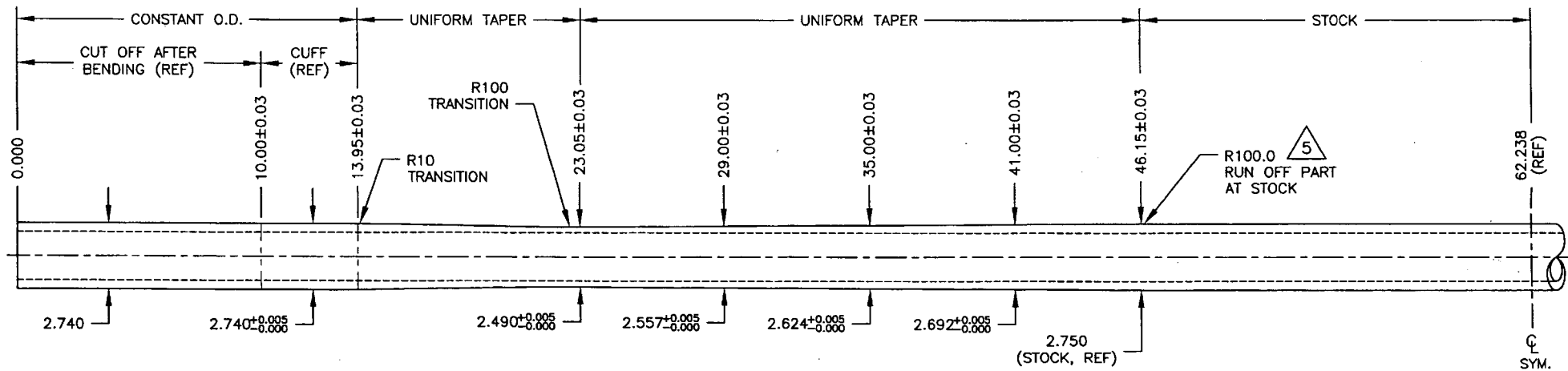


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DESIGN 90	DRAWN BY 90	DART	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED #	APPROVED #	DRAWING NO. D412-664-145	REV. C SHEET 2 OF 3
DATE 07.03.29		TITLE CROSSTUBE (412 LOW-NARROW FWD)	SCALE 1:2

SHOP COPY
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D412-664-145 MACHINING DETAIL

RELEASED

07.04.99

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DATE 07.03.29		DRAWING NO. D412-664-145		SHEET 3 OF 3
TITLE CROSTUBE (412 LOW-NARROW FWD)		SCALE 1:4		

DART AEROSPACE LTD		Work Order: 38012
Description: Cross tube Assembly (412 Low Norm. w/ FWD)		Part Number: D412-664-105
Inspection Dwg: D412-664-105 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☐ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.740"	$\pm .005$	2.742				
2.490"	$\pm .005$	2.492				
2.557"	$\pm .005$	2.562				
2.624"	$\pm .005$	2.629				
2.692"	$\pm .005$	2.693				
124.48"	$\pm .020$	124.50				
2.740"	$\pm .005$	2.740				
2.490"	$\pm .005$	2.494				
2.557"	$\pm .005$	2.562				
2.624"	$\pm .005$	2.629				
2.692"	$\pm .005$	2.694				

Measured by: a.m./J.F.	Audited by: <i>mk</i>	Prototype Approval:
Date: 08-03-24	Date: 08/03/27	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	

